Friday, 9/21/2007 1:19:06 PM

Kim Johnston .User:

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** : 34826

: 12522

P.O. Number

Previous Run

This Issue : 9/21/2007

: NC Prsht Rev.

First Issue

: 9/21/2007

: 33300

Written By Checked & Approved By

Comment

: Est Rev:A New Issue 06-09.06 EC

S.O. No. : NA

Type

: SMALL /MED FAB

Project Number **Drawing Revision**

Drawing Number

Part Number

Drawing Name

Material **Due Date** : D35311

: BRACKET ASS'Y

: N/A

07/09/24

5 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6S040

6061-T6 .040 Sheet

Total:

Comment: Qty.: 0.3972 sf(s)/Unit 6061-T6 .040 Sheet

> (M6061T6S040) Batch: M (CO)

1.9861 sf(s)

2.0

WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3531 Dwg Rev: A.

Prog Rev:_

图 07-10-3



2-Deburr if necessary

INSPECT PARTS AS THEY COME OFF MACHINE

3.0

B 07-10-3



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

BRAKE NC

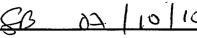
NC BRAKE





Comment: NC BRAKE

Bend as per Dwg D3531



Dart Aerospace Ltd

W/O:		WORK ORDER CHA	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: _	 PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:	07/18/18
			QA: N/C C	losed:	Date:	

Description of NC Section A	Initial	Corrective Action Section B		l		
	Initial			Verification	Approval	Approval
	Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
price was trop out of Toterana at the	O Sur	Screp & destroy	875 07 1801/2	Co Hulon	wan	Solule
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NOTE: Date & initial all entries

Friday, 9/21/2007 1:19:06 PM Date: User: Kim Johnston **Process Sheet** 'Customer: CU-DAR001 Dart Helicopters Services Drawing Name: BRACKET ASS'Y Job Number: 34826 Part Number: D35311 Job Number: Description: Seq. #: **Machine Or Operation:** INSPECT WORK TO CURRENT STEP QC5 6.0 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING1 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 8.0 QC3 07-10-10 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION m PACKAGING RESOURCE #1 9.0 Comment: PACKAGING RESOURCE #1 Identify and Stock 07-10-10 Location: GP FINAL INSPECTION/W/O RELEASE 10.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date `	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector			
				,			:			
			·							

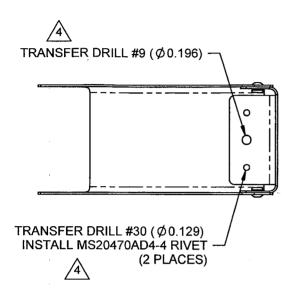
Part No:	PAR #:	Fault Category:	NCR: Yes	No DQA :	Date:
			QA: N	I/C Closed:	Date:

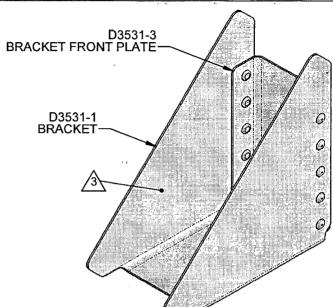
NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC	Description of NC Corrective Action Section B			Verification	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
											
						·					

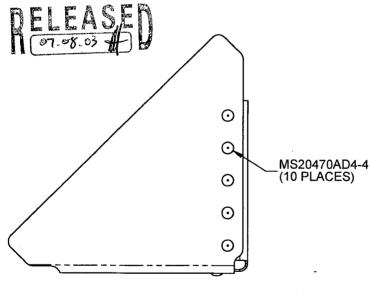
NOTE: Date & initial all entries

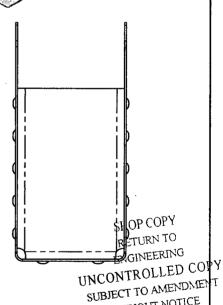


	DESIGN DRAWN BY			DART AEROSPACE HAWKESBURY, ONTARIO, CA	
	CHECK	(ED	APPROVED	D3531	REV. A SHEET 1 OF 3
	DATE	07.0	06.19	BRACKET ASSEMBLY	SCALE 1:2
٦	REV		DATE	DESCRIPTION	
	Α		07.06.19	NEW ISSUE	









WITHOUT NOTICE

D3531-041 BRACKET ASSEMBLY

NOTES:
1) FINISH: POWDER COAT ASSEMBLY BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3 ALL PARTS

2) ASSEMBLE PER DART QSI 003

3) IDENTIFY WITH DART P/N "D3531-041" USING WHITE MARKER ON INSIDE OF BRACKET

ASSEMBLY, WHERE INDICATED
4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET THROUGH D3531-3 BRACKET FRONT PLATE **BEFORE FINISHING**

PARTS LIST

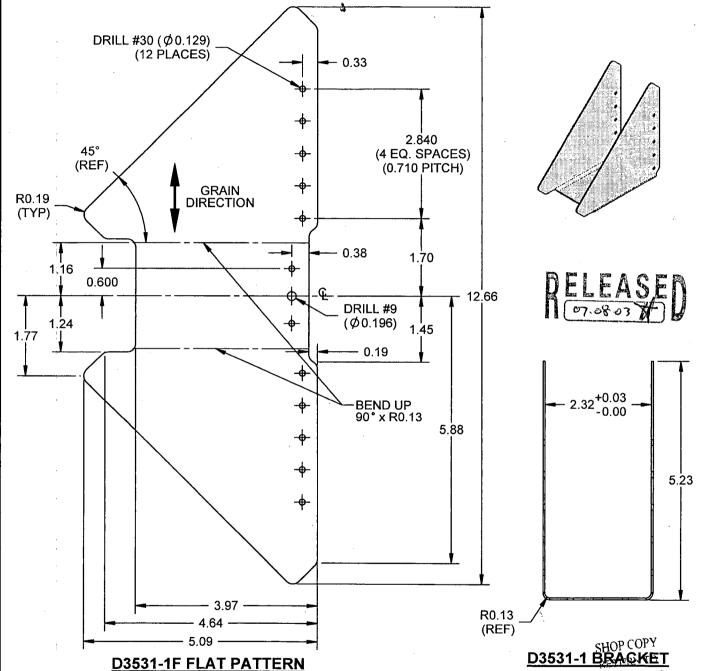
ARTS L	<u>IST</u>	WORK & STA
QTY.	P/N	DESCRIPTION
Х	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

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	CHECKED	APPROVED	DRAWING NO.	REV. A	
	<u> </u>	M	D3591	SHEET 2 OF 3	
١	DATE		TITLE	SCALE	
	07.06.19		BRACKET ASSEMBLY	1:2	



ENGINEERING

NOTES 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR UNCONTROLLED COPY
AMS 4025 OR AMS 4027 (REF DART SPEC MEDIATES 0.40)

AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP CORNERS TO 0.010 MAX

6) PART IS SYMMETRIC ABOUT &

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

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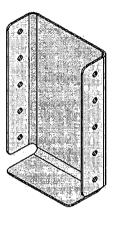
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CB DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. A	
LE	TN	D3531	SHEET 3 OF 3	
DATE		TITLE	SCALE	
07.	.06.19	BRACKET ASSEMBLY	1:2	

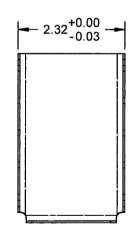
DRILL #30 3.72 (00.129)0.75 0.37 (TYP) (10 PLACES) 0.33 Ъ 0 0 2.840 3.68 3.50 (4 EQ. PLACES) 0 (0.710 PITCH) 4.67 0 0 0 0.88 BEND UP (TYP) 90° X R 0.13

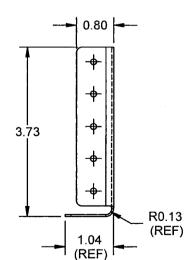




D3531-3F FLAT PATTERN

R0.125 (TYP)





D3531-3 BRACKET FRONT PLATE

NOTES:

1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED 5) BREAK ALL SHARP CORNERS TO 0.010 MAX 6) PART IS SYMMETRIC ABOUT &

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

3482

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DART AEROSPACE LTD	Work Order: 34826
Description: BRACKET ASS'V	Part Number: 17 203 1~1
Inspection Dwg: 353 Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	
dp. 🛇	f.005001	. 199	×			
× .139	1002001	,130	X			
,33	4- ,030	.33	×			
O48.6	4010	2,840	*			
(.70	4/030	1.70	¥			
1.45	4/030	1.45	¥			
.38	+/- ,030	,38	کمہ			
.19	4/036	119	×			
5,88	+/030	5.88	¥			
12.66	+/036	12,66	¥			
.600	t/ .010	(,60)	*			
1.77	+/036	1.77	*			
1.24	4/036	1.24)			
طا. ا	t/ 1030	1.16	15			
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Measured by:	Audited by:	co	Prototype Approval:	4.1	۸
Date: 07-10-3	Date:	A(10/13	Date:	~/	μ

A New Issue Revised by App	proved

